

Work Order ID 72756

Friday, August 12, 2011 9:00:53 AM



Page 1

Item ID: D412-682-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Beam

Start Date: 8/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-08-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D412-682	Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD412-682-001

CHG001

Sulor/12

for BG 11-9-15

130

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

Pick Packing Kit ☐ *****Ensure original Bell ARC and Tags are packaged in kit*****

11/6/9 SP (12)

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sulor/12

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72756

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Item Name: Support Beam

Start Date: 8/12/2011 Start Qty: 1.00



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Required Date: 8/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD412-682-001 Location: <u>SI</u> PPP Rev: <u>A</u>								
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/9/238

11/9/270

MF
11-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 12, 2011 9:00:58 AM

Page 1

Work Order ID: 72756

Parent Item: D412-682-001

Parent Item Name: Support Beam



Start Date: 8/12/2011

Required Date: 8/19/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 08.03.19 new issue EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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604-028-001		Purchased	No			110	Each	0.0000	1	1			
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412 Bolt (412-050-008-101)

604-030-001		Purchased	No			110	Each	0.0000	1	1			
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412 Rocker beam (412-050-003-109)

AN320-8		Purchased	No			110	Each	36.0000	1	1			
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Nut

Location Loc Qty Loc Code

ST324 36

106552 36

MS24665-285		Purchased	No			110	Each	101.0000	1	1			
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Cotter Pins

Location Loc Qty Loc Code

ST309 101

9003 101

NAS1149F0832P		Purchased	No			110	Each	253.0000	1	1			
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WASHER

Location Loc Qty Loc Code

ST275 253

18057 253

M118973 8/11/12

M118999 W

SP

SP

11/9/9 SP

T

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

LANDING GEARS KITS (HIGH)

Qty -001	Qty -011	Qty -011B	Qty -013	Qty -015	Qty -021	Qty -025	Qty -035	Part Number	Description
X								D412-682-001*	SUPPORT BEAM KIT
	X							D212-682-011	LANDING GEAR KIT HIGH, 205/210/212
		X						D212-682-011B	LANDING GEAR KIT HIGH, 214
			X					D212-682-013	LANDING GEAR KIT HIGH, 204
				X				D412-682-015	LANDING GEAR KIT HIGH, 412
					X			D212-682-021	LANDING GEAR KIT, 205/210/212, APICAL FLOAT COMPATIBLE
						X		D412-682-025	LANDING GEAR KIT, 412, APICAL FLOAT COMPATIBLE
							X	D412-682-035	LANDING GEAR KIT, 412, OEM/APICAL FLOAT COMPATIBLE
	1		1	1	1	1	1	D212-664-101	CROSSTUBE FWD HIGH, 204/205/210/212/412
		1						D212-664-101B	CROSSTUBE FWD HIGH, 214
	1		1		1			D212-664-201	CROSSTUBE AFT HIGH, 204/205/210/212
		1						D212-664-201B	CROSSTUBE AFT HIGH, 214
				1		1	1	D412-664-203	CROSSTUBE AFT HIGH, 412
	2	2		2				D205-634-011	SKIDTUBE, 205/210/212/214/412
			2					D204-635-011	SKIDTUBE, 204
							2	D412-742-011	FLOAT SKIDTUBE, OEM/APICAL, 412
					2	2		D412-742-013	FLOAT SKIDTUBE, APICAL, 205/210/212/412
1								412-050-003-113	SUPPORT BEAM ASSEMBLY (OR AAI P/N 604-030-001)
1								412-050-008-101	BOLT (OR AAI P/N 604-028-001)
1								AN320-8	NUT
1								MS24665-285	COTTER PIN (OR AN380-3-4)
1								NAS1149F0832P	WASHER

LANDING GEARS KITS (STANDARD AND LOW NARROW)

Qty -111	Qty -111B	Qty -113	Qty -115	Qty -117	Part Number	Description
X					D212-682-111	LANDING GEAR KIT STANDARD, 205/210/212
	X				D212-682-111B	LANDING GEAR KIT STANDARD, 214
		X			D212-682-113	LANDING GEAR KIT STANDARD, 204
			X		D412-682-115	LANDING GEAR KIT STANDARD, 412
				X	D412-682-117	LANDING GEAR KIT LOW NARROW, 412
				1	D412-664-105	CROSSTUBE FWD LOW NARROW, 412
1		1	1		D212-664-107	CROSSTUBE FWD STANDARD, 204/205/210/212/412
	1				D212-664-107B	CROSSTUBE FWD STANDARD, 214
				1	D412-664-205	CROSSTUBE AFT LOW NARROW, 412
1		1			D212-664-207	CROSSTUBE AFT STANDARD, 204/205/210/212
	1				D212-664-207B	CROSSTUBE AFT STANDARD, 214
			1		D212-664-209	CROSSTUBE AFT STANDARD, 412
2	2		2	2	D205-634-011	SKIDTUBE, 205/210/212/214/412
		2			D204-635-011	SKIDTUBE, 204

CUSTOMERS REQUESTING THE ARMOR SHIELD OPTION ON CROSSTUBES SHOULD ORDER THE ABOVE CROSSTUBE/LANDING GEAR KITS WITH AN "A" EXTENSION.

IE. D212-664-101 CROSSTUBE WITH ARMOR SHIELD = D212-664-101A
D212-682-021 LANDING GEAR WITH ARMOR SHIELD = D212-682-021A

*CUSTOMERS THAT REQUIRE THE SUPPORT BEAM ASSEMBLY ON 412 AIRCRAFT CAN PROCURE THE D412-682-001 SUPPORT BEAM KIT

E	ADD D212-682-011B/-111B	CP	09.03.30
D	ADD D212-682-111/-113 AND D412-682-001/-115/-117	PH	08.02.12
C	ADD -021/-025/-035, ADD ARMOR SHIELD	PH	06.10.26
B	ADD D412-682-015	DS	03.06.09
A	NEW ISSUE	DS	01.02.23
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. E
MFG. APPR.	N/A	D212-682	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	LANDING GEAR KITS	NTS
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